

Block for SO#10189

Work Order ID 58257

Monday, May 03, 2010 8:59:13 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 5/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-5-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3914

A

100



Weld per dwg A/R S.S. rod Batch: M113328

0.00

Large Fab

Memo

0.00

- 1- assemble ribs, weld as per dwg D3914
- 2- weld hinge (3) and Mounting brackets as per dwg D3914
- ***inspect before welding mesh***
- 3- tack weld mesh on basket as per dwg D3914

10/05/12 1x
PL →

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

PL 10/05/12

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3914-041 PAR #: Fault Category: Large RAs NCR: Yes No DQA: Date: 1005-11
 Resolution: rework Disposition: rework QA: N/C Closed: Date: 10/25/17

NCR: 58252		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/05/11 #100		After welding lid empty in new DT 7607A employee notices that the lids D4035-041 and D4035-043 were not in the correct sides of basket lid empty to the D4035-043 R.F. empty welder was not paying attention to new sig. and drawing	DSUR	- Remove the existing brackets & grind the welds flush. - Ensure the lid is in the correct orientation & weld	N/A misinform		DSUR	S early
			DSUR	on new D25801 & D4016-3 logs per the drawing. part is S.S. & will not be affected by re-welding.			DSUR	1005-11
			DSUR	- Remove D4035-041 and D4035-043 Scrap them Replace with new one and weld in correct place	10/05/12	DSUR	DSUR	DSUR

NOTE: Date & initial all entries

D4035-041 Batch: 358192

D4035-043 Batch: 358193

Work Order ID 58257

Monday, May 03, 2010 8:59:13 AM



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Item ID: D3914-041

Revision ID:

Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2010 Start Qty: 1.00

Required Date: 5/7/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

~~Fit is very tight to base~~
Memo

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M 10.5642

Memo

0.00

Start

Item

Tin

2:15pm

320°F

2:45pm

M 10/03/12

X1

✓

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

14482

Memo

0.00

- 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg
- 2- Install placard and label as per dwg

① BR 10-5-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 58257

Monday, May 03, 2010 8:59:13 AM



Page 3

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 5/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

150



QC3- Inspect Part Finish

QC

Quality Control

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Identify as per dwg & Stock Location:

6A

0.00

Packaging

Packaging

Memo

w/o 58313

0.00

EB/10/05/13

EB/10/05/13

170



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

1005-14

MF 10-5-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, May 03, 2010 8:59:12 AM

Page 1 / 3

Work Order ID: 58257



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2010

Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	27.0000	2		10/05/11	

Mounting Bracket

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA	27	
	46086	2	
	51745	2	
	57185	23	

D2728-3



Manufactured No 140 Each 0.0000

②

EP 05/13

Dart Logo label

D3914-1



Manufactured No 100 Each 0.0000

②

B58241 ② 10/05/11

Rib

D3914-7



Manufactured No 100 Each 2.0000

②

B58242 ② 10/05/11

Rib



	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	WA	2	
	57573	2	

D4016-3



Manufactured No 100 Each 13.0000

③

10/05/11

Hinge Half, Lid

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST109	12	
	57574	12	
	WA	1	
	56950	1	

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 58257



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2010

Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4018-5		Manufactured		No		100	Each	0.0000	9			



✓ Rib

D4020-5



Mesh (350 Basket Long, Lid)

		Manufactured		No		100	Each	1.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

B58244 (9) 10/05/11

		Manufactured		No		100	Each	1.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

B58245 (1) 10/05/12

		Manufactured		No		100	Each	2.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

B58246 (0) 10/05/11

		Manufactured		No		100	Each	2.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

✓ D4021-3



Data Plate

		Manufactured		No		100	Each	2.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

B58246 (0) 10/05/11

		Manufactured		No		100	Each	2.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

✓ D4035-041



Lid Rib Assembly, Fwd (350 Basket)

		Manufactured		No		100	Each	1.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

B58192 (0) 10/05/11

		Manufactured		No		100	Each	1.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

✓ D4035-043



Lid Rib Assembly, Aft (350 Basket)

		Manufactured		No		100	Each	1.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

B58193 (0) 10/05/11

		Manufactured		No		100	Each	1.0000	1			
--	--	--------------	--	----	--	-----	------	--------	---	--	--	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 58257



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2010

Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4086-210

Manufactured

No

140

Each

8.0000

1

Placard, Max Load

Location	Loc Qty	Loc Code
ST112	8	
56978	8	

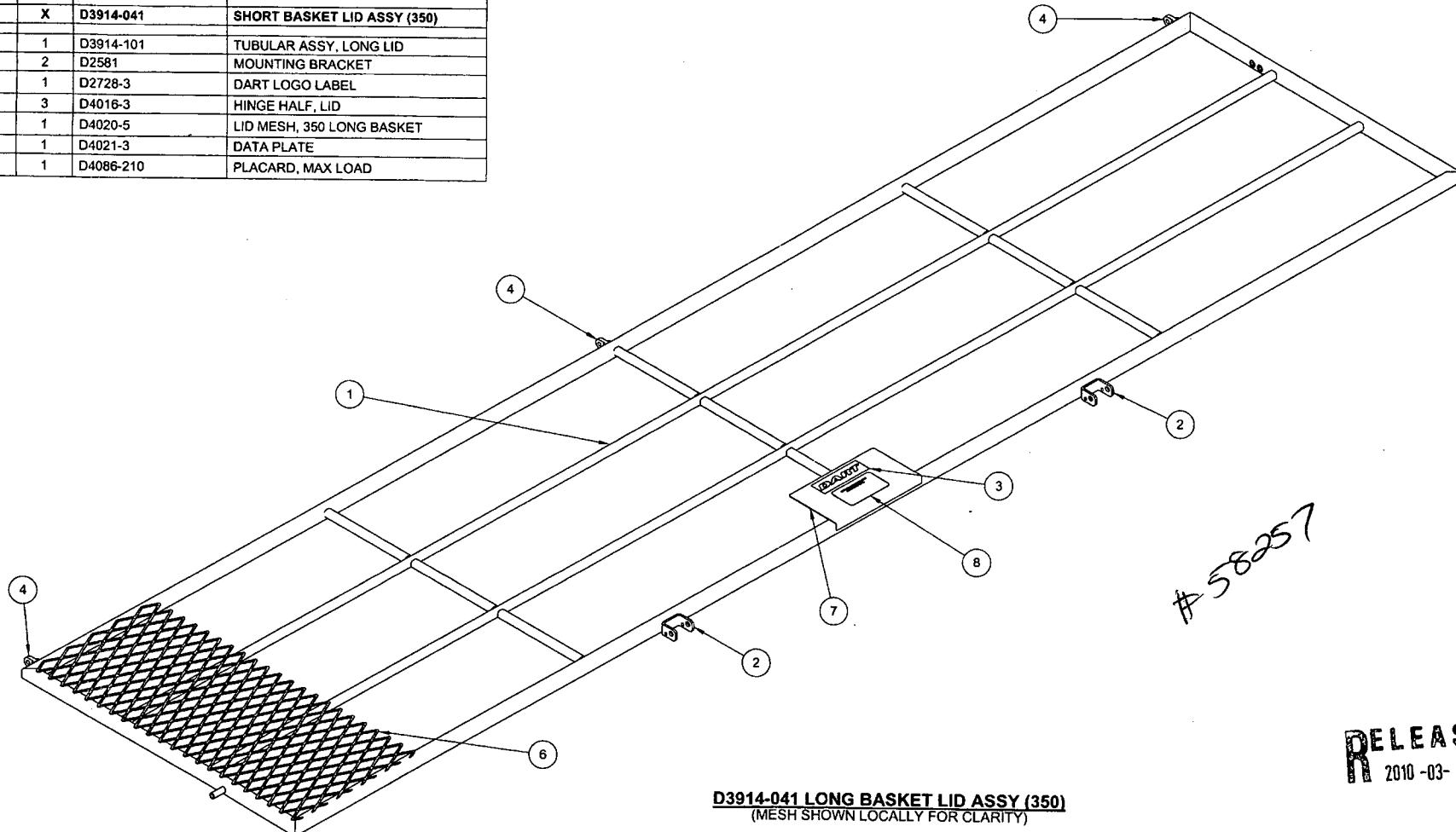
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

A		NEW ISSUE	JPH	10.03.16
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH	DRAWING NO. D3914		
CHECKED		REV. A SHEET 1 OF 4		
MFG. APPR.		TITLE LONG BASKET LID ASSY (350)		
APPROVED		SCALE NTS		
DE APPR.				
DATE	10.03.16			

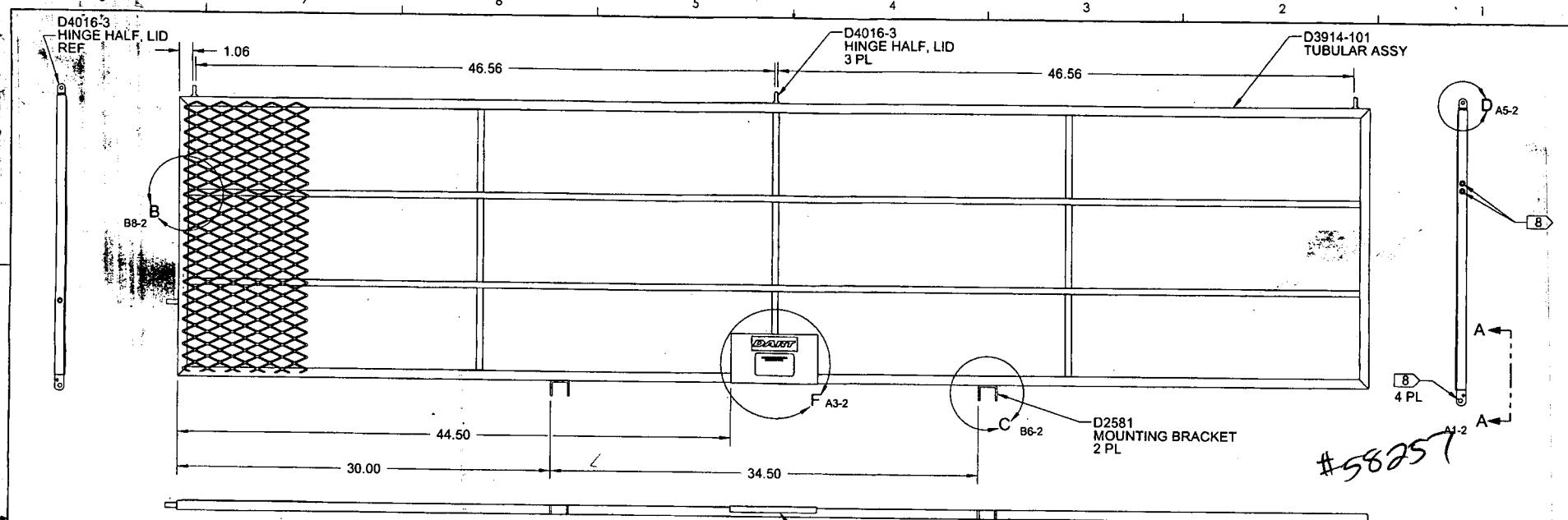
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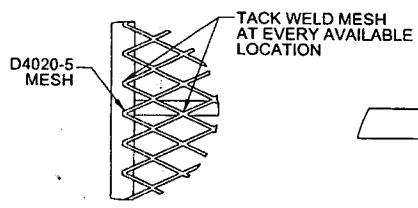
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

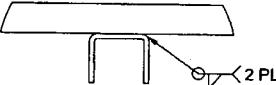
NOTE: Date & initial all entries



RELEASED
2010-03-22

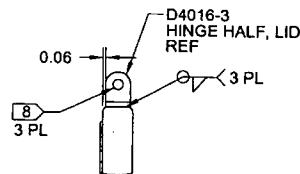


DETAIL B B8-2

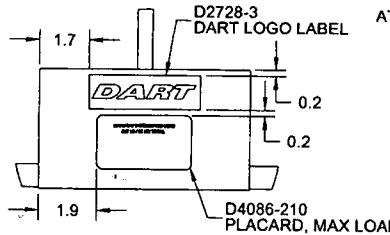


DETAIL C C3-2

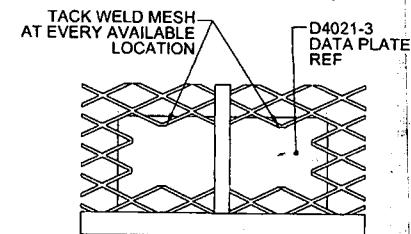
D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



DETAIL D D1-2



DETAIL F C4-2



VIEW A-A C1-2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO.
MFG. APPR.		D3914
APPROVED		REVISION SHEET 2 OF 4
DE APPR.		TITLE LONG BASKET LID ASSY (350)
DATE	10.03.16	SCALE NTS

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W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

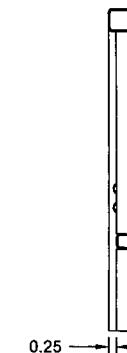
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

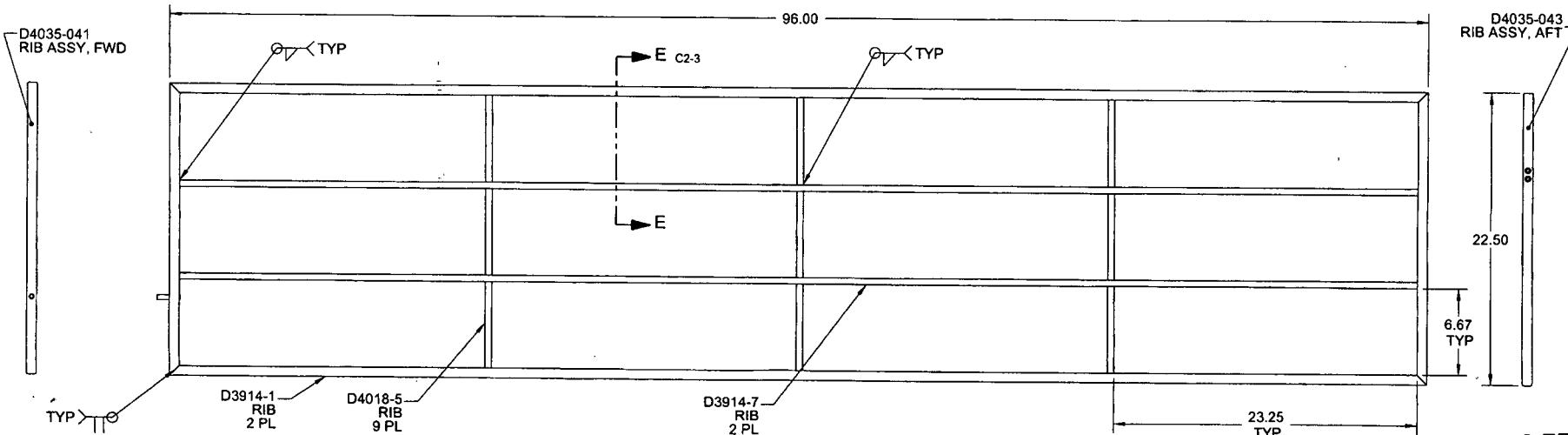
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



RELEASED
2010-03-22
JAD

8 > D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	A	DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3914
DE APPR.		SHEET 3 OF 4
DATE	10.03.16	TITLE
		SCALE
		LONG BASKET LID ASSY (350) NTS
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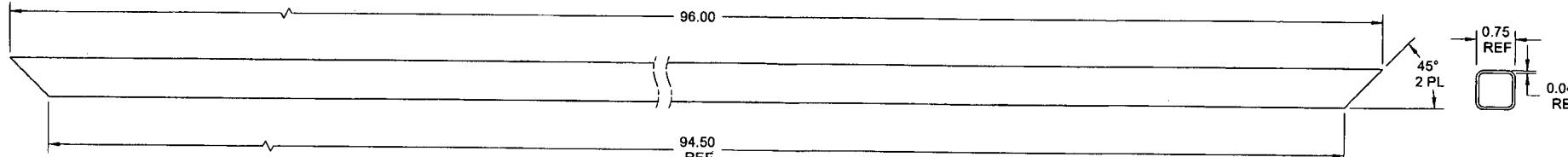
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8 7 6 5 4 3 2 1

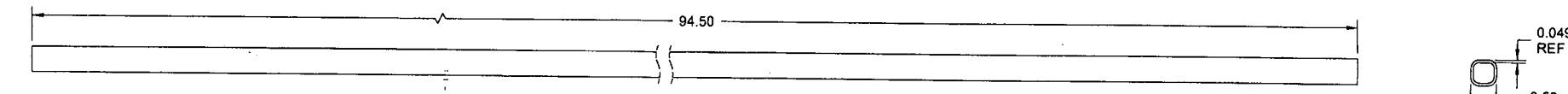
D

D



C

C



B

B

NOTES:

1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

8 7 6 5 4 3 2 1

RELEASED
R 2010-03-22
NW

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	X	DRAWING NO.	REV. A
MFG. APPR.	X	D3914	SHEET 4 OF 4
APPROVED	X	TITLE	SCALE
DE APPR.	X	LONG BASKET LID ASSY (350)	
DATE	10.03.16	NTS	

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